

Work Order ID 57107

March 22, 2010 10:08:42 AM



Page 1

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 22/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 25/03/2010 Req'd Qty: 20.00



Customer:

Reference:

Ref. 10.03.22

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3910

A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.450" LONG

DJP 10/03/22

20 *Ø*

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: A

DWG REV: B

MMF
10/03/24

20 *Ø*

DEBURR

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

MWF
10/03/24

20

Ø

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

S/S 10/03/29

20

Ø

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

H 10/03/29

X20

Ø

Hand Finishing

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Customer:

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

Memo

START: 7:00am

TEMP: 320°F

FIN: 7:30am

0.00

⇒ M

10/03/30

X20

Ø

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BR

10-3-30

(20)

Ø

170



Packaging

Packaging

Identify as per dwg & Stock Location: ST507

0.00

Memo

0.00

P149/5

(20)

Work Order ID 57107

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Page 4

Item ID: D3910-1

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Cust Item ID:

Required Date: 25/03/2010 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/06 *[Signature]*
MF 10-4-5

Picklist Print

March 22, 2010 10:08:41 AM

Page 1

Work Order ID: 57107



Parent Item: D3910-1



Parent Item Name: Crosstube Lug



Start Date: 22/03/2010

Required Date: 25/03/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	566.3488	2.7368			
												
Lug Extrusion												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

566.3488432

43722

173.462806

44529

5.7731

45800

387.112937

2,7368 *DD* 10/03/22

DART AEROSPACE LTD		Work Order: 5707
Description: Crosstube Lug		Part Number: D3910-1
Inspection Dwg: D3910 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

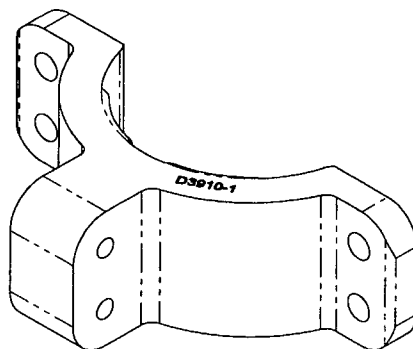
☐

Prototype

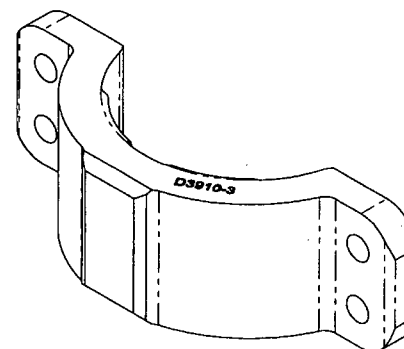
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.45	$\pm .03$	4.45	✓			
1.38	$\pm .03$	1.37	✓			
3.700	$\pm .010$	3.700	✓			
.625	$\pm .010$.627	✓			
.375	$\pm .010$.376	✓			
.375	$\pm .010$.376	✓			
Ø .257	$^{+.006}_{-.001}$.260	✓			
.31	$\pm .03$.308	✓			
R 1.20	$\pm .03$	1.22	✓			
2.20	$\pm .03$	2.20	✓			
.375	$\pm .010$.375	✓			
.625	$\pm .010$.625	✓			
.380	$\pm .010$.376	✓			
Ø .191	$^{+.005}_{-.001}$	Ø .195	✓			
R .38	$\pm .03$.375	✓			

Measured by: MW	Audited by: SA	Prototype Approval: N/A
Date: 10/03/24	Date: 10/03/24	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3910-1 X-TUBE LUG







D3910-3 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

RELEASED
2010-03-22
MD

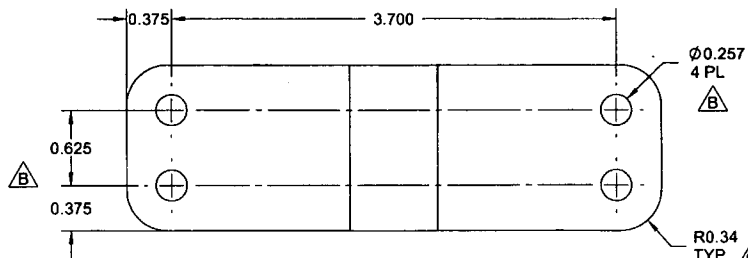
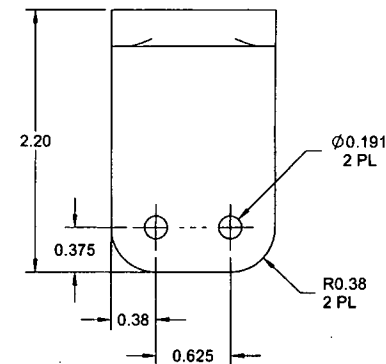
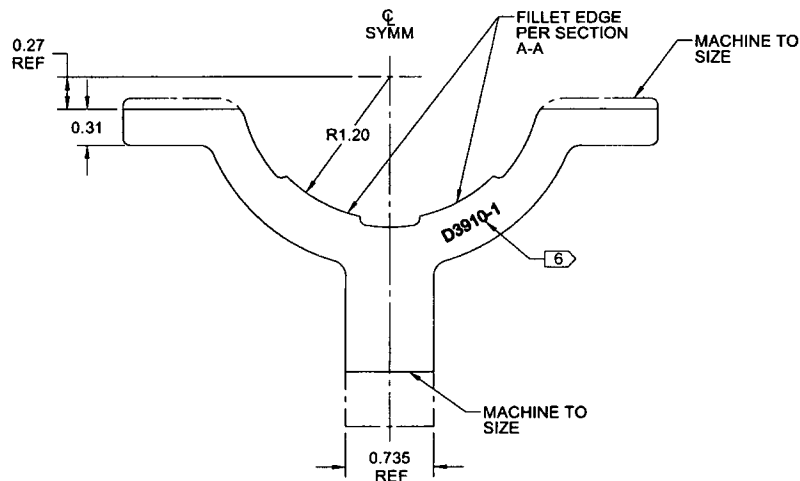
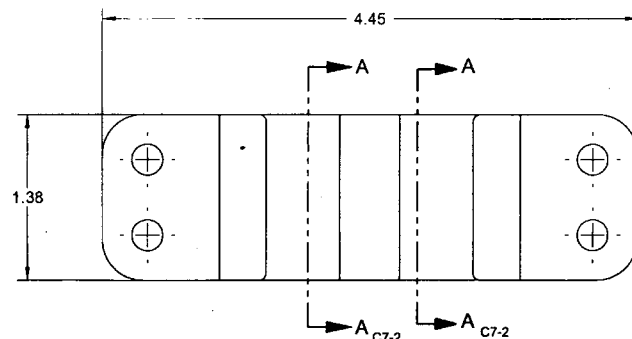
57107

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NT	
DATE	10.03.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



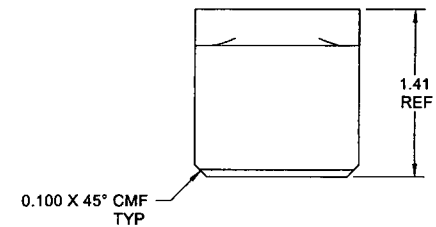
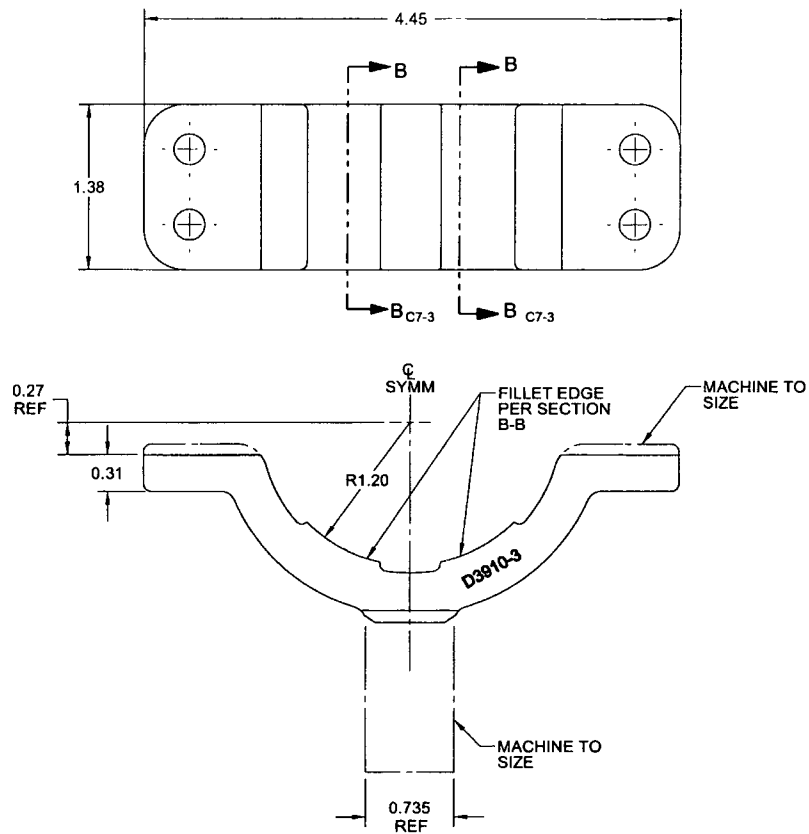
D3910-1 X-TUBE LUG

57107



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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 2 OF 3
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3910	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
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2010-03-22

57107